Work Orde Thursday, Augus				*129	3464*							Page 1
Item ID: Revision ID: Item Name:	D3492-3			Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	·· [ \]	S1* S2*
	8/07/14	Start Qty: 100.00 Req'd Qty: 100.00			Cust Item l Customer:	ID:						
Approvals:	Process Pla	an: MUJ	Date: 14-08-68	Tooling:	Da	ate:			Run	Start	*N	R1*
			Date:		Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr	440									
D3492	E											2 to 8 to
100		II II ONG LABUR	CMANA	0.00				اشت عمر ن		1		2 1 3
<u>*1</u> 00*		Hardinge CNC LATHE	SMALL	0.00				100	)	$\mathcal{P}_{-}$		14-8-19
Hardinge Hardinge CNC Lath	ne Small	Memo 1-Turn as p Dwg Rev:_ Folio Rev:_	per Folio FA632 & Dwg D3 ビールノム	0.00 492						,		8 5 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8
110		QC2- Inspect parts off i	machine FAI/FAIB	0.00						,		æ
*110* QC Quality Control		Мето		0.00				100	<u>9</u>	<u>\$</u>		14-8-19
120		QC8- Inspect parts - sec	cond check,	0.00				160	,	<b>∝</b>		DAS 40
*120* QC		Memo		0.00				<u> (60</u>		<u>P</u>		9-89 14/02/20

DQA:			. Date:									•	*DART
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UI		ork Order up	odate only	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er: <u>-</u>	<u></u>			<del></del> .	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	lo.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Desc	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_					•							·
Handling/Pre	_												
Material									·				
Operator							1						
Offset/Setup									[				
Process													
Supplier Training	-						1						
Transport	$\neg$												
Unapproved			1										
					L		FA	ULT CA	TEGORY		. •		
Landir	ng (	Gear			٥.	General					•		
		Bending				Bend		Folio/F	Program	, .	Outside Dim	ensions	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí _	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/L	Jnclear	Part Moved	Ĺ	Wrong Stock Pulled
		Crushing	X			Countersink		Misalig	gned/off center		Positioned V		$\neg$
		Heat Trea	at			Cut Too Short		Mislabe			Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea					
	L	Marks/Cl	hatter			Drill Holes	$\perp$	Off-set		•			
	_	1	Sequence		<u> </u>	Finish	_	-	Calibration				
Ţ		Wave/Tv	vist in Tuk	ре		Fit/Function		Out of	Sequence				

Work Order ID 12346
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\*123464\*

Page 2

Thursday, August 07,	2014 11:16:17 AM			34(34						
Item ID: D349 Revision ID: Item Name: Plug			Accept	*N900	<u>040</u>	100	<b>)*</b> s	etup Star	171	S1* S2*
Start Date: 8/07/ Required Date: 8/07/ Reference:	~ 0	*100 *100		Cust Item I Customer:	D:					
Approvals: Pro	•	Date:	Tooling: SPC (Y/N):		ate:		R	dun Star Stop	^IV	R1* R2*
Sequence ID/ Work Center ID  130  *120* HandFinish Hand Finishing  140  *120* Powder Coating	Operation Description Chemical Conversion Coat  Memo  White Gloss(Ref.4.3.5.1) pe  Memo (Flat End Only START TIME: OVEN TEMPE FINISH TIME:	or QS1005 4.3-Alum 959 200 erature:30	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool #	Plan Code		Reject Qty		Stamp  Insp.
150 *150* QC Quality Control	QC3- Inspect Part Finish  Memo		0.00				[00]	K		14/08/28

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DQA:	QA: Date:										TAART		
·						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UF	PDATE		_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Manle Ond						DISPOSITION				AGAINST DI	EPARTMENT,	PROCESS	·
Work Orde	er: .				<u> </u>	Rework	7 Î		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	۱o.					Scrap		1	Machining	Small Fab		d. Eng. Coor.	Quality
NCD						Use-as-is		Thern	noforming	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
NCR I	NO					Suspected Unapproved	١		Large Fab	Composite		Jupplier	
Root					Desci	ription of work order update	I	nitial	Acti		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	n QC Inspector
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Handling/Pre													
Material													
Operator					:								
Offset/Setup		1							1				
Process	Ш		ļ										
Supplier													
Training	_												
Transport			Ì										
Unapproved						<del> </del>	<u> </u>		<u> </u>		.,		1
							FA	ULI CA	TEGORY		· · · · · · · · · · · · · · · · · · ·		
Landi	ng (	1				General	_	1	<b></b>	. г	70		Pressure/Forced
		Bending	_		-	Bend	$\vdash$	1 .	Program	-	Outside Dim	1	Set-up
	_	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	-	Grain		-	Over/Under	•	Temperature/Cure
	$\vdash$	Cracks				Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorred		<del></del>
	_	Crimp/Kit	nk/Ripple	/Wave	<u> </u>	Burrs	$\vdash$	4 '	ion Incomplete/Un	<del></del>	Part Lost/Mi	ssing	Weld
	<u> </u>	Cuffs			<u> </u>	Contamination	-	-1	tions Incomplete/U	nciear	Part Moved	/rang	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	$\vdash$	- 1	gned/off center	 	Positioned V	~ I	Othor
	$\vdash$	Heat Trea			<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	ontge	Other
	<u> </u>	Inspectio		Tube	<u> </u>	Drawing	<u> </u>	Misrea					
	<u> </u>	Marks/Cl				Drill Holes	-	Off-set					
	<u></u>	Turning S			$\vdash$	Finish	<u> </u>	4	Calibration				
1	1	Wave/Tw	ist in Tub	be		Fit/Function		Out of:	Sequence				

Work Order ID 12	23464
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Thursday, Augu				*12:	3464*						Page 3	
Item ID: Revision ID: Item Name:	D3492-3 Plug		,	Accept	*N90004	010	<b>)</b> *	Setup	Start Stop	171.	S1* S2*	-
Start Date: Required Date: Reference:	8/07/14 8/07/14	Start Qty: 100.00 Req'd Qty: 100.00	*100* *100*		Cust Item ID: Customer:				S4 4			
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:		}	Run	Start Stop	^!\	R1* R2*	
Sequence ID/ Work Center II 160 *160* Packaging Packaging	D	Operation Description Identify as per dwg & Stor	ck Location: 17-60	Set Up/ Run Hours 0.00	Tool ID Tool	# Plan Code	Accept Qty	Qty		Reject Number	Insp. Stamp	- '
170 <b>*170*</b> QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00			MUS	<u> </u>		3-02	 14-09-07	2

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DQA: Date:										AC.	RT			
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UP			,	AEROS	PACE
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT	PROCESS		
WOIK OIG	٠.					Rework	ı İ		Skid-tube	Crosstube	7	Water Jet	Engineering	g
Part N	lo.					Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	_
	•					Use-as-is	1		noforming	Finishing	_	e/Packaging	Othe	r
NCR I	۱o.					Suspected Unapproved	]		Large Fab	Composite	]	Supplier		
Root					Desc	ription of work order update		nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verificatio	n QC Inspe	ctor
Design														
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Equip/Tooling							l							
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier			ļ											
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Unapproved			<u> </u>	<u> </u>	i		FΔ	IIIT CA	TEGORY				<u> </u>	
Landi	na (	Goor		<del></del>		General	17	OLI CA	120011			<del>_</del> -		
Landi	E \	Bending				Bend		] <sub>Folio/F</sub>	Program	Г	Outside Dim	ensions	Pressure/Forc	ed
		Centre N	ot Conce	ntric		BOM/Route	$\vdash$	Grain		<u> </u>	Over/Under		Set-up	
	_	Cracks	or comec.			Broken/Damage/Defect	$\vdash$	Hardwa	are	<del> </del>	Part Incorre		Temperature/	Cure/
		Crimp/Kii	nk/Ripple	e/Wave		Burrs	-	4	ion Incomplete/Un	ngualified	Part Lost/Mi	ssing	Weld	
		Cuffs		,		Contamination	$\vdash$	4 '	tions Incomplete/U	<del></del>	Part Moved		Wrong Stock F	Pulled
	Г	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea				Cut Too Short	一	Mislabe		Γ	Power Loss/	Surge	Other	
		Inspectio		Tube		Drawing		Misrea	d	<b></b>				
		Marks/Cl				Drill Holes		Off-set						
		Turning S		!		Finish		Out of	Calibration					
'		Wave/Tw				Fit/Function		Out of	Sequence					

Thursday, August 07, 2014 11:16:17 AM

Work Order ID: 123464

\*123464\*

Parent Item:

D3492-3

\*D3492-3\*

Parent Item Name: Plug

**Start Date: 8/07/14** 

Required Date: 8/07/14

**Start Qty: 100.00** 

Required Otv: 100.00

**Comments:** 

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No		. ,	100	f	20.4941	0.06	7			13 9-89
*M6061T6	SR0 750	*							**	14-8	8-19		- 04

6061-T6 Round Bar .750"

Loc Code Loc Qty Location MAT012 20.494052 3.494052 m126852 17 m128573

M6061T6R0.750 M128573

DQA:			Date:										*DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		/ork Order up	odate only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	· ·
Work Order	r:		-			Daanlı	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part No	o					Rework Scrap Use-as-is			Machining noforming	Small Fab Finishing	_	d. Eng. Coor.	Quality Other
NCR N	o				de-Filia	Suspected Unapproved	]	l	Large Fab	Composite		Supplier	
Root	$\neg$				Desc	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre				1									
Material													
Operator													
Offset/Setup												:	
Process				ļ									
Supplier													
Training					]								
Transport					Į.				1				
Unapproved			1										
							FA	ULT CA	TEGORY			···	
Landin	ıg G	ear				General		-		-	_		_
		Bending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
-		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect	L	Hardwa	are		Part Incorre	cí <u> </u>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/U	Inclear	Part Moved	Ĺ	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center	L	Positioned V	Vrong _	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	_			
] [		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	эе		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order: 123494
Descriptions	8317
Description:	Part Number: 103992-3
Inspection Dwg: D3492 Rev: E	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
.060	±.005 =.010	.060				
500	=-010	.500				
-060	±-005	-060				
050 (20°	±.010/±.50	05 X20°				
. ଓ ୩୦	+,000/-,002	.088				
.045	4.000/002	.0445				
0.582	=.010	-582				***
0-750	=.010	.748				
<del></del>						
İ						
					•	
	DAS 13		DAS			

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

**D3492-XXX PLUG PARTS LIST** 

DO402-AAX 1 EUG 1 AKTO EIGT										
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION	7
X				i				D3492-041	PLUG ASSEMBLY	7
	х							D3492-043	PLUG ASSEMBLY	1
		Х						D3492-045	PLUG ASSEMBLY	7
			Х					D3492-047	PLUG ASSEMBLY	
				Х				D3492-049	PLUG ASSEMBLY	7
					Х			D3492-051	PLUG ASSEMBLY	7
						Х		D3492-053	PLUG ASSEMBLY	٦.
							Х	D3492-055	PLUG ASSEMBLY	7£
										]
1								D3492-1	PLUG	_
	1							D3492-3	PLUG	_
		1				·	_	D3492-5	PLUG	_
			1					D3492-7	PLUG	_
				1				D3492-9	PLUG	
					1			D3492-11	PLUG	
						1		D3492-13	PLUG	] .
							1	D3492-15	PLUG	Æ
_		1						NAS1611-005	O-RING	-
		<u> </u>	1					NAS1611-007	O-RING	1
1								NAS1611-010	O-RING	┪
						-1		NAS1611-012	O-RING	1
	1							NAS1611-013	O-RING	1
$\rightarrow$				-					···	1
			_		1		1	NAS1611-015	O-RING	4
				1				NAS1611-016	O-RING	J

 $\frac{\mathsf{NOTES};}{\mathsf{1)}\,\mathsf{O}\text{-RING};}\,\mathsf{POSSIBLE}\,\,\mathsf{SUPPLIER}\,\,\mathsf{P/N};\,\mathsf{NAS1611\text{-}XXX}\,\,\mathsf{OR}\,\,\mathsf{PARKER}\,\,\mathsf{2\text{-}XXX}$ 

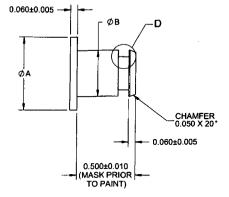
SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 123464 MLJ 14-08-08

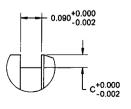
Е	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN PH		DART AEROSPACE LTD			
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA			
CHECKED	A55	DRAWING NO.	REV. E		
MFG. APPR.	177	D3492	SHEET 1 OF 2		
APPROVED	149	TITLE	SCALE		
DE APPR.	-#	PLUG	NTS		
DATE 13 0	8 08	COPYRIGHT © 2007 BY D	DART AEROSPACE LTD		

D

POWDER COAT THESE FACES ONLY PER NOTE 2





**DETAIL D** 

## D3492-XX PLUG

## **D3492-XX PLUG MACHINING DETAILS**

	MATERIAL SPEC	С	В	A	P/N	
-	M6061T6R0.625	0.050	0.394	0.625	D3492-1	
	M6061T6R0.750	0.045	0.582	0.750	D3492-3	
	M6061T6R0.375	0.045	0.188	0.375	D3492-5	
	M6061T6R0.500	0.045	0.270	0.500	D3492-7	
	M6061T6R1.000	0.045	0.750	0.938	D3492-9	
	M6061T6R0.875	0.045	0.664	0.850	03492-11	
	M6061T6R0.750	0.045	0.510	0.750	03492-13	
	M6061T6R0.875	0.050	0.640	0.850	03492-15	

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHÈMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN	PH		OSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	A55	DRAWING NO.	REV. E	
MFG. APPR.	177	D3492	SHEET 2 OF 2	
APPROVED	10	TITLE	SCALE	
DE APPR.	-#-	PLUG	4:1	
DATE 13.0	80.80	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPETENTIAL AND IS SUPPLED ON THE ESPECIAL CORN FROM THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON LODGED ON COMMUNICATION ON ANY OTHER PERSON WITHOUT		

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